

# Work Order ID 85571

Monday, June 11, 2012 10:46:31 AM

**\*85571\***

*Today*

Page 1

Item ID: D3694-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: MOUNTING PLATE

Stop

**\*NS2\***

Start Date: 6/11/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 6/11/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *12-06-11*

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3694

Rev C

100

0.00

**\*100\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install helicoils as per Dwg D3694-Install Protective & Mounting plate as per Dwg D3694

*1X*

*12/05/11*

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*SMB 12-9-12*  
*DAS 16*  
*12/6/12*

120

Identify as per dwg & Stock Location *248 A*

0.00

**\*120\***

Packaging

Memo

0.00

Packaging

*12/8 12/9/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85571****\*85571\***

Page 2

Item ID: D3694-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: MOUNTING PLATE

Stop **\*NS2\***

Start Date: 6/11/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 6/11/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept Reject Reject Insp.  
Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/9/18

K/1209-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 11, 2012 10:46:30 AM

Page 1

Work Order ID: 85571

Parent Item: D3694-041

Parent Item Name: MOUNTING PLATE

Start Date: 6/11/2012

Required Date: 6/11/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM  
IPP Rev:B 09-01-13 As per Rev C JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R8 Screw		Purchased	No				Each	549.0000		2		6/12/06/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		549							
				9216		549							
AN960JD10 Washer	NAS1149D0363J	Purchased	No				Each	0.0000		10		6/12/06/11	
D3694-1 Mounting Plate		Manufactured	No				Each	2.0000		2		6/12/06/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		2							
				56906		2							
D3694-3 MOUNTING PLATE ASSY		Manufactured	No				Each	8.0000		2		6/12/06/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		8							
				56907		8							
D3694-5 MOUNTING PLATE ASSY		Manufactured	No				Each	9.0000		2		6/12/06/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		9							
				46200		1							
				56908		8							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, June 11, 2012 10:46:30 AM

Page 2

Work Order ID: 85571

Parent Item: D3694-041

Parent Item Name: MOUNTING PLATE

Start Date: 6/11/2012

Required Date: 6/11/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L3 Purchased No Each 1,983.0000

8

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1983	
115835	4	
117885	32	
119017	884	
119075	138	
121349	115	
121444	810	

MS21209-F120 Purchased No Each 131.0000

4

HELI COIL

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST304	131	
114037	31	
121709	100	

MS24693-C271 Purchased No Each 5,530.0000

2

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST310	5530	
1112	3736	
1139	1183	
1445	383	
1664	228	

MS24693-C273 Purchased No Each 86.0000

8

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST310	86	
120308	25	
121060	61	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

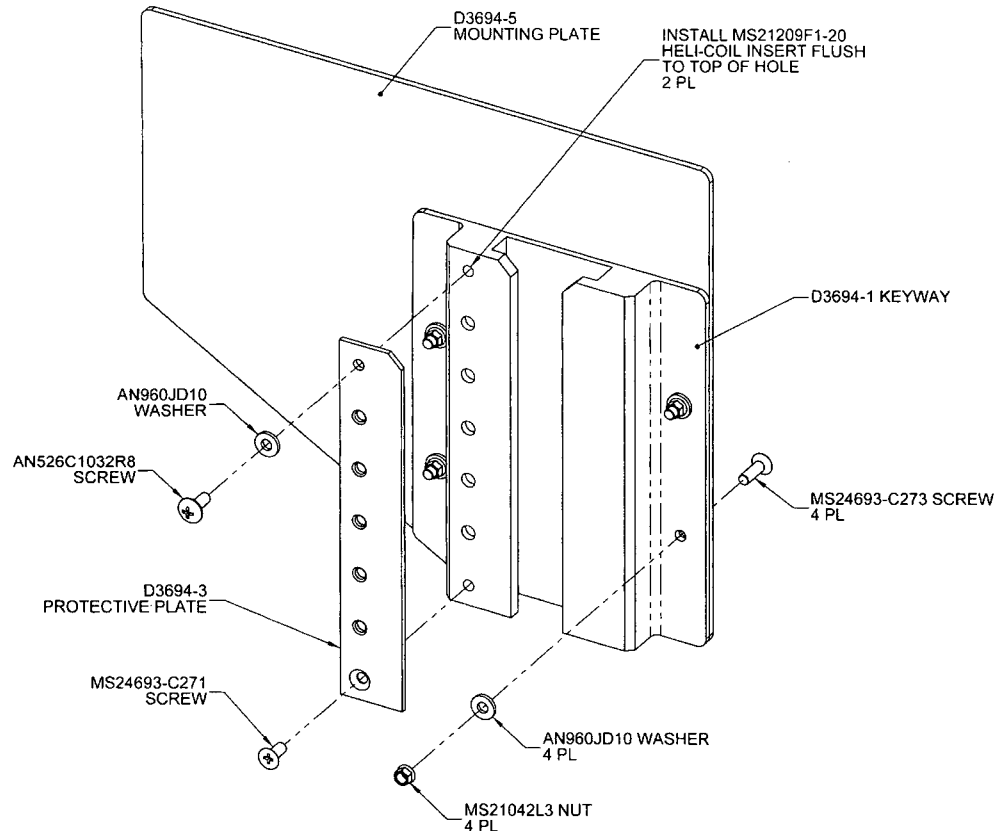
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3694-041 MOUNTING PLATE ASSY**

**D3694-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS2109F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

# 8571

**RELEASED**  
08/12/05

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D6-3); ADDED ITEM 13: UPDATED BOM TO CURRENT STANDARDS (ZN D3-1); REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3); REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C  
TITLE **MOUNTING PLATE ASSY** SCALE NTS  
SHEET 1 OF 4

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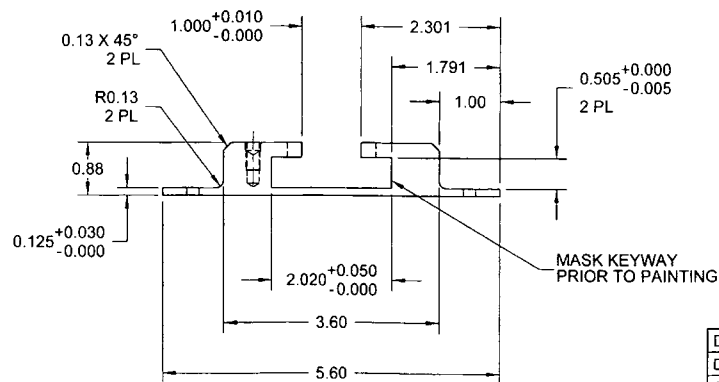
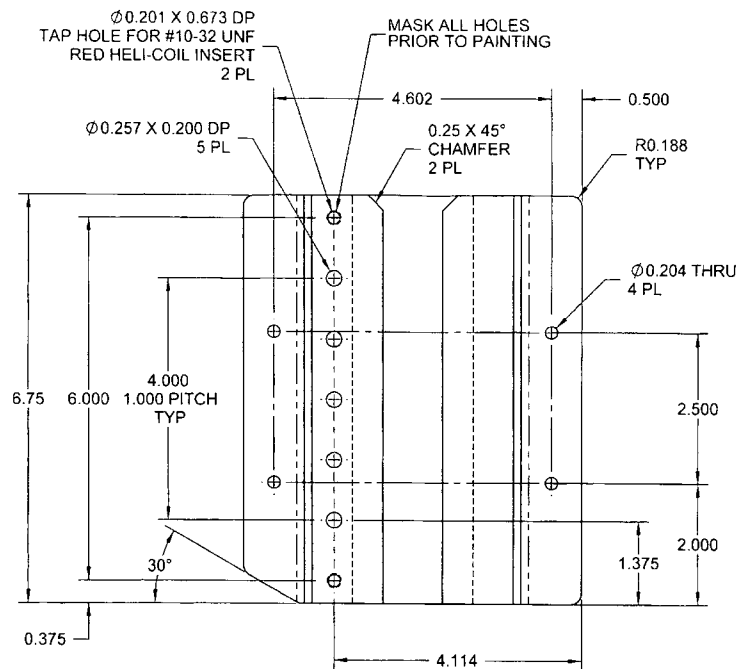
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D3694-1 KEYWAY**

**D3694-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART  
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

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MFG. APPR.		<b>D3694</b>	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING PLATE ASSY</b>	NTS
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**RELEASED**  
29/02/05

#855 71

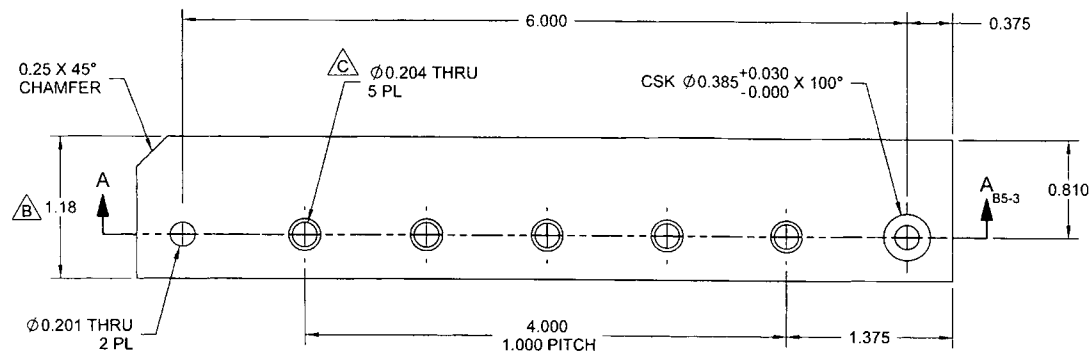
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

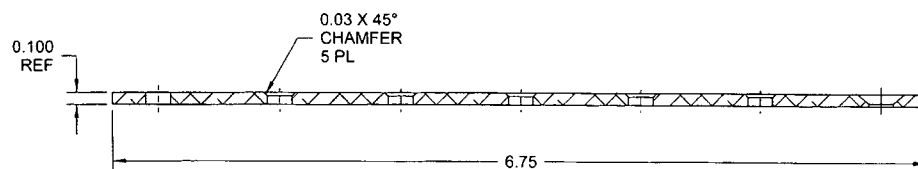
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



### D3694-3 PROTECTIVE PLATE



### SECTION A-A C3-3

#### D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),  
PER PER AMS 5513 OR AMS 5524  
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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RELEASED  
09/26/05

#85571

**Dart Aerospace Ltd**

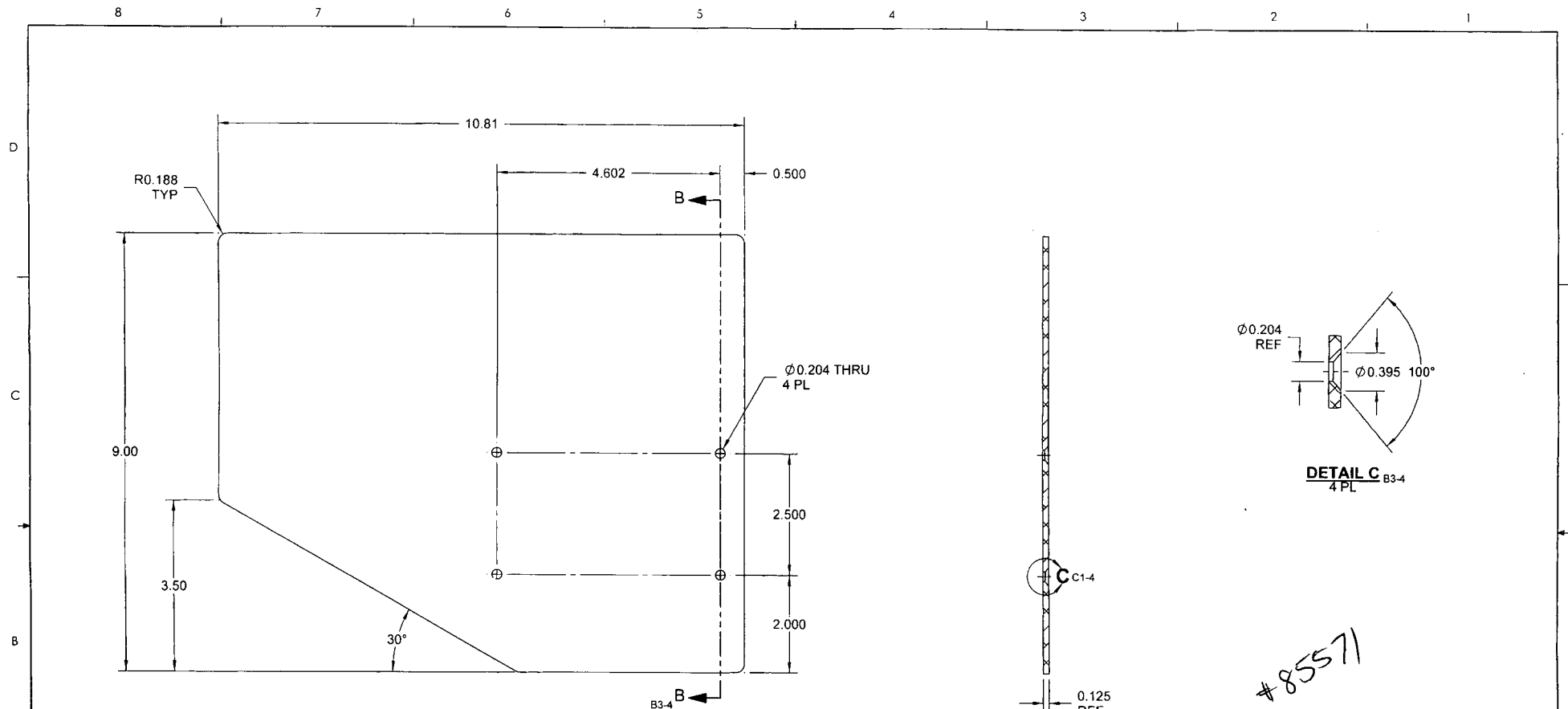
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**NOTE:** Date & initial all entries



**D3694-5 MOUNTING PLATE**

**SECTION B-B B5-4**

**DETAIL C B3-4**

#85571

**RELEASED**  
09/05/05

**D3694-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027  
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 4 OF 4
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DE APPR.		MOUNTING PLATE ASSY	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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